

Work Order ID 56500

February 25, 2010 10:54:35 AM



Page 1

Item ID:	D3391-025	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Aft Tube Assembly					
Start Date:	2/25/10	Start Qty:	1.00		Cust Item ID:	
Required Date:	3/05/10	Req'd Qty:	1.00		Customer:	
Reference:						

Approvals:	Process Plan:		Date:	2-25	Tooling:		Date:	
	QC:		Date:		SPC (Y/N):		Date:	

Run	Start	
	Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3391	Rev H								
100	MORI SEIKI CNC LATHE LARGE	0.00							
	Mori Seiki								
Mori Seiki CNC Lathe Large	Memo	0.00							
	Turn as per Folio FA599			Rev: AA & Dwg D3391 Rev: H					
	scribe batch # on fwd end at 90 degree								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
	QC								
Quality Control	Memo	0.00							
111	QC8- Inspect parts - second check	0.00							
	QC								
Quality Control	Memo	0.00							

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Required Date:	3/05/10	Req'd Qty:	1.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 HAAS 1 HAAS CNC vertical machine #1	HAAS CNC VERTICAL MACHINING #1 Memo 1-Machine as per Folio FA 599 Rev: <u>AA</u> & Dwg D3391 Rev: <u>H</u> 2-Deburr	0.00 0.00				<u>1</u>	<u>0</u>		
130 QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00				<u>1</u>	<u>0</u>		
140 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00				<u>1</u>	<u>0</u>		

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Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 	Skidtubes	0.00							
Skidtubes	Memo	0.00							
Skidtubes	1-Drill (PILOT HOLE) aft cap holes per Dwg D3391 using DT8803								
160 	BENDING MACHINE - SKIDTUBES	0.00							
CNC Bend 1	Memo	0.00							
CNC Delta 100 Bender	Form as per Dwg D3391 Using Bend Prog 3391025								
170 	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									

DP

10-3-16

DP

10-3-16

h=4.125"

5/10/16

Ⓢ

W/O:		WORK ORDER CHANGES					
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Reference:

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--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

180

0.00



Skidtubes

Skidtubes

Skidtubes

Memo

0.00

1-Open Aft cap pilot hole to .208" as per Dwg D3391

2-Drill float bag holes using DT8809 as per Dwg D3391(Holes marked "A" Only.

3-Drill wearplate holes as per Dwg D3391 using DT8878(Mid Tube) & DT8217
Wearplate Jig.

*****Do Not Open To Finished Size*****

4-Drill Wearshoe holes as per DWG D3391 using DT8939 locating from 2
previously drilled aft wearplate holes.

5-Open wearplate holes to 0.250" and c'bore as per dwg D3391

6-Open up all wearshoe, wearplate to 0.297"and float bag holes to 0.328" as per
Dwg D3391.

7-Deburr

1

41013117

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Customer:

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Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00	Sobor 17						
200 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00	DP 10-3-17						
210 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00	M 10/3/17						

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Customer:

Reference:

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Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

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220	Skidtubes	0.00							
Skidtubes	Memo	0.00							
Skidtubes	Instal spacers as per dwg D3391 A/R Magnabond 6398 Batch: <u>112417</u> exp. date: <u>10/7/30</u> cure time 12hrs as per QSI0015								
230	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									
240	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
Powdercoat	Memo	0.00							
Powder Coating	START TIME: <u>8:00</u> OVEN TEMPERATURE: <u>320°</u> FINISH TIME: <u>8:30</u>								

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10/08/30	230.1	Pressure wash & Realign As per PAR-043	gll	10/08/30	1		

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



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250

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

→ M

10-108/31

1

0

260

HandFinishing

0.00



HandFinish

Memo

0.00

Hand Finishing

1-Install inserts as per Dwg D3391

2-Install Aft Cap as per Dwg D3391

A/R Sikaflex-241/-291 11/11/14

Sikaflex expiry date: 11/11

→ M

10/08/31

1

0

270

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

M

10

09

01

①

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Customer:

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
280	Identify as per dwg & Stock Location: <i>W10 61475</i>	0.00							
	Packaging					<i>ml</i>	<i>10</i>	<i>09</i>	<i>01</i> <i>(1)</i>
	Memo	0.00							
	Packaging								
290	QC21- Final Inspection - Work Order Release	0.00							
	QC	0.00							
	Quality Control								

*10/09/01**MF*
10-9-01

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Picklist Print

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Parent Item: D3391-025

Parent Item Name: Aft Tube Assembly

Start Date: 2/25/10

Required Date: 3/05/10

Comments: IPP Rev B 06-02-07 ECN773 dwg rev. D EC
IPP Rev:C 06-03-28 Update Manuf. Instructions JLM □□□□
IPP rev D 07.03.20 revF dwg EC
IPP rev E 07.11.07 rev G dwg ecn 1053p EC verified by: DD

Start Qty: 1.00

Required Qty: 1.00

D6014-090

Manufactured No

100

Each

11.0000

1.0000



ALUMINUM EXTRUSION

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

LG

42768

11

11

230

Each

83.0000

4.0000

D3670-4-200

Manufactured No



SPACER

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

48198

48269

83

4

79

DP 10-3-17

4

AWM 10-3-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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 IPP Rev:C 06-03-28 Update Manuf. Instructions JLM ☐ ☐ ☐
 IPP rev D 07.03.20 revF dwg EC
 IPP rev E 07.11.07 rev G dwg ecn 1053p EC verified by: DD

Start Qty: 1.00

Required Qty: 1.00

D2646 Manufactured No 270 Each 52.0000 1.0000



Aft Cap

Warehouse	Loc Qty	Loc Code
Location		

Main Warehouse

FP6

29

1357332

x1 10/08/31

52663

29

Main Warehouse

fp7

13

52663

13

Main Warehouse

ST

10

46327

4

48109

6

D3537-1 Manufactured No 270 Each 140.0000 1.0000



Wearpad

Warehouse	Loc Qty	Loc Code
Location		

Main Warehouse

FP

74

48288

2

1360492

x1 10/08/31

55465

72

Main Warehouse

FP17

66

51678

1

51679

65

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Start Date: 2/25/10

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 IPP Rev:C 06-03-28 Update Manuf. Instructions JLM ☐ ☐ ☐
 IPP rev D 07.03.20 revF dwg EC
 IPP rev E 07.11.07 rev G dwg ecn 1053p EC verified by: DD

Start Qty: 1.00

Required Qty: 1.00

D3537-7 Manufactured No 270 Each 14.0000 1.0000



Wearpad

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 14

45408 3

46346 11

D3553-1 Manufactured No 270 Each 9.0000 1.0000



Gasket

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 9

33868 9

D3553-3 Manufactured No 270 Each 58.0000 1.0000



Gasket

Warehouse Loc Qty Loc Code
Location

Main Warehouse

FP 58

53480 58

xl yl 10/08/31

xl yl 10/08/31

xl yl 10/08/31

W/O:		WORK ORDER CHANGES					
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 IPP Rev:C 06-03-28 Update Manuf. Instructions JLM □□ □□
 IPP rev D 07.03.20 revF dwg EC
 IPP rev E 07.11.07 rev G dwg ecn 1053p EC verified by: DD

Start Qty: 1.00

Required Qty: 1.00

D3672-1 Manufactured No 270 Each 1,682.000 2.0000



Phenolic Washer

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	1182	
39275	19	
42329	5	
47628	158	
52505	1000	
Main Warehouse		
ST117	500	
51674	500	

x2 xl 10/08/31

ALS4-1032-130 Purchased No 260 Each 1,678.000 14.0000



Insert

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	1678	
110511	1678	

M 114723 x 14 xl 10/08/31

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 IPP rev D 07.03.20 revF dwg EC
 IPP rev E 07.11.07 rev G dwg ecn 1053p EC verified by: DD

Start Qty: 1.00

Required Qty: 1.00

ALS4-1032-225

Purchased

No

270

Each

6,230.000 12.0000



Insert

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

6230

107441

16

110768

6214

x12 JH 10108131

AN3C4A

Purchased

No

270

Each

1,033.000 6.0000



BOLT

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

1033

112314

13

112720

12

112724

3

112829

1

112991

2

113121

64

113226

344

113644

394

113749

200

1114491

x6 JH 10108131

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 IPP rev D 07.03.20 revF dwg EC
 IPP rev E 07.11.07 rev G dwg ecn 1053p EC verified by: DD

Start Qty: 1.00

Required Qty: 1.00

AN3C5A Purchased No 270 Each 465.0000 4.0000



Bolt

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

465

M 115015

2.4 JH 10/08/31

111424

8

111707

69

112314

1

113121

125

113149

262

AN960C10L Purchased No 270 Each 388.0000 10.0000



washer X NAS 1149C0332R

Warehouse Loc Qty Loc Code

Location

OFFSHORE

FG

100

M 115000

X10 JH 10/08/31

103585

100

Main Warehouse

ST

288

112116

128

112612

160

W/O:		WORK ORDER CHANGES					
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DART AEROSPACE LTD		Work Order: 56500
Description: Float Skidtube (412)		Part Number: D3391-3
Inspection Dwg: D3391	Rev: H	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Lathe Section						
14.000	+/-0.010	14.000	✓			
3.500	+/-0.010	3.500	✓			
88.93	+/-0.030	88.93	✓			
44.995	+/-0.030	44.995	✓			
Ø3.200	+/-0.010	3.200	✓			
88.93	+/-0.030	88.93	✓			
Ø3.750	+/-0.010	3.750	✓			
30° x 160° chamfer	+/-0.010	30° x 160°	✓			

Measured by: M3 / ALM	Date: 10-03-04
Audited by:	Date:

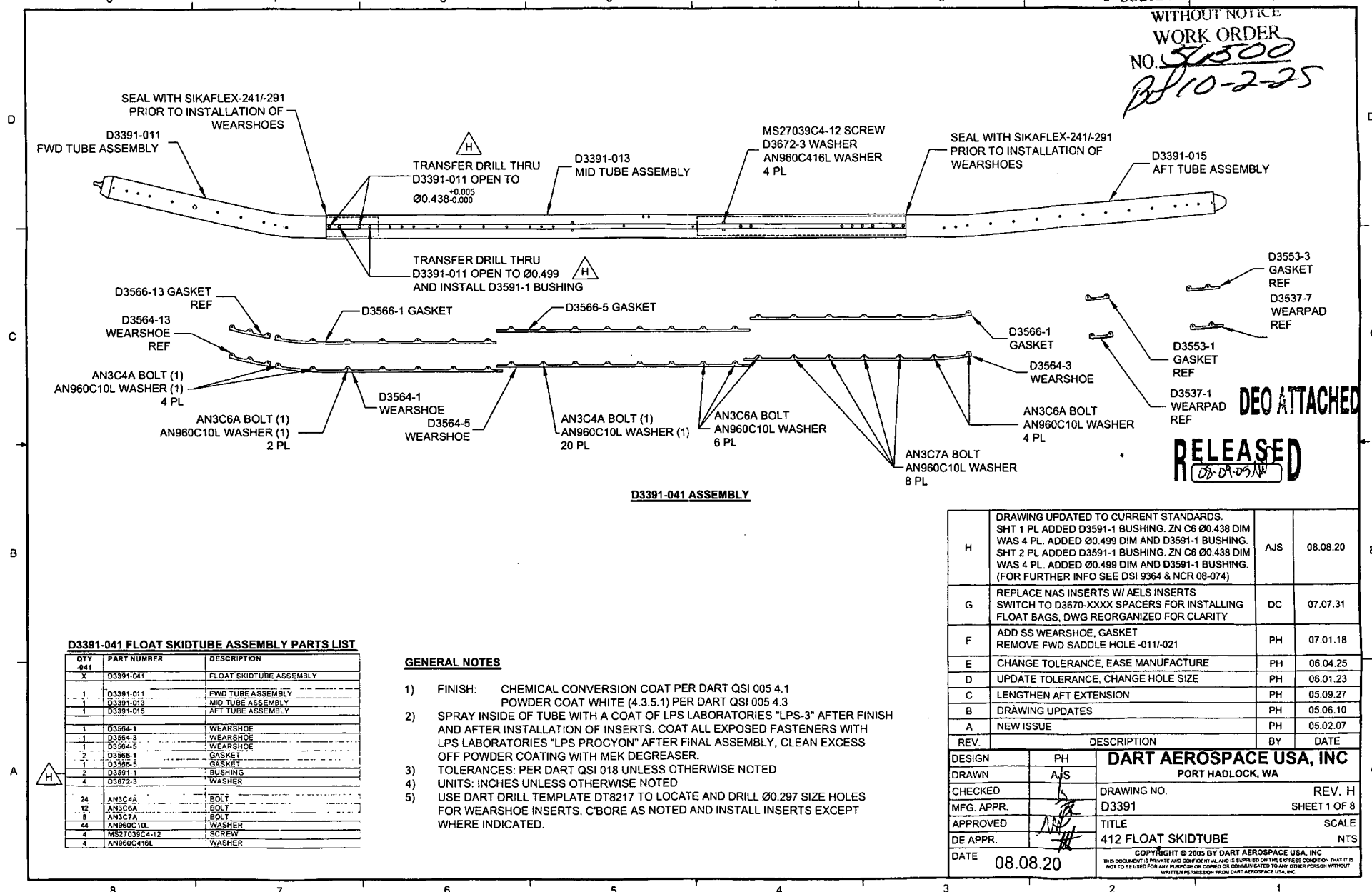
HAAS Section						
1.526	+0.000/-0.030	1.526	✓			
7.500	+/-0.010	7.500	✓			
27.750	+/-0.010	27.750	✓			
31.750	+/-0.010	31.750	✓			
35.250	+/-0.010	35.250	✓			
3.300	+/-0.010	3.295	✓			
0.200	+/-0.010	.200	✓			
3.520	+/-0.010	3.521	✓			
0.687	+0.010/-0.000	.691	✓			
R0.062	+/-0.010	R.062	✓			
Ø0.484	+0.005/-0.001	Ø.489	✓			

Measured by: [Signature]	Date: 10/03/09
Audited by: [Signature]	Date: 10/03/09

Rev	Date	Change	Revised by	Approved
A	06.04.24	New Issue P/O D3391-015/-025	KJ/JLM	
B	06.06.19	Dwg revision update	KJ/JLM	
C	07.04.20	Ø0.208 dimension removed	KJ/JLM	
D	07.09.06	0.400 dimension removed	KJ/JLM	
E	07.11.23	Dwg Rev. updated	KJ/EC/DD	
F	09.04.27	Dimensions updated per Rev H and NCR09-028	KJ/JLM	
G	09.11.16	Dimension 0.200 removed	KJ	

WITHOUT NOTICE
WORK ORDER

NO. *51500*
BS10-2-25



DEO ATTACHED

RELEASED
08-08-20

D3391-041 ASSEMBLY

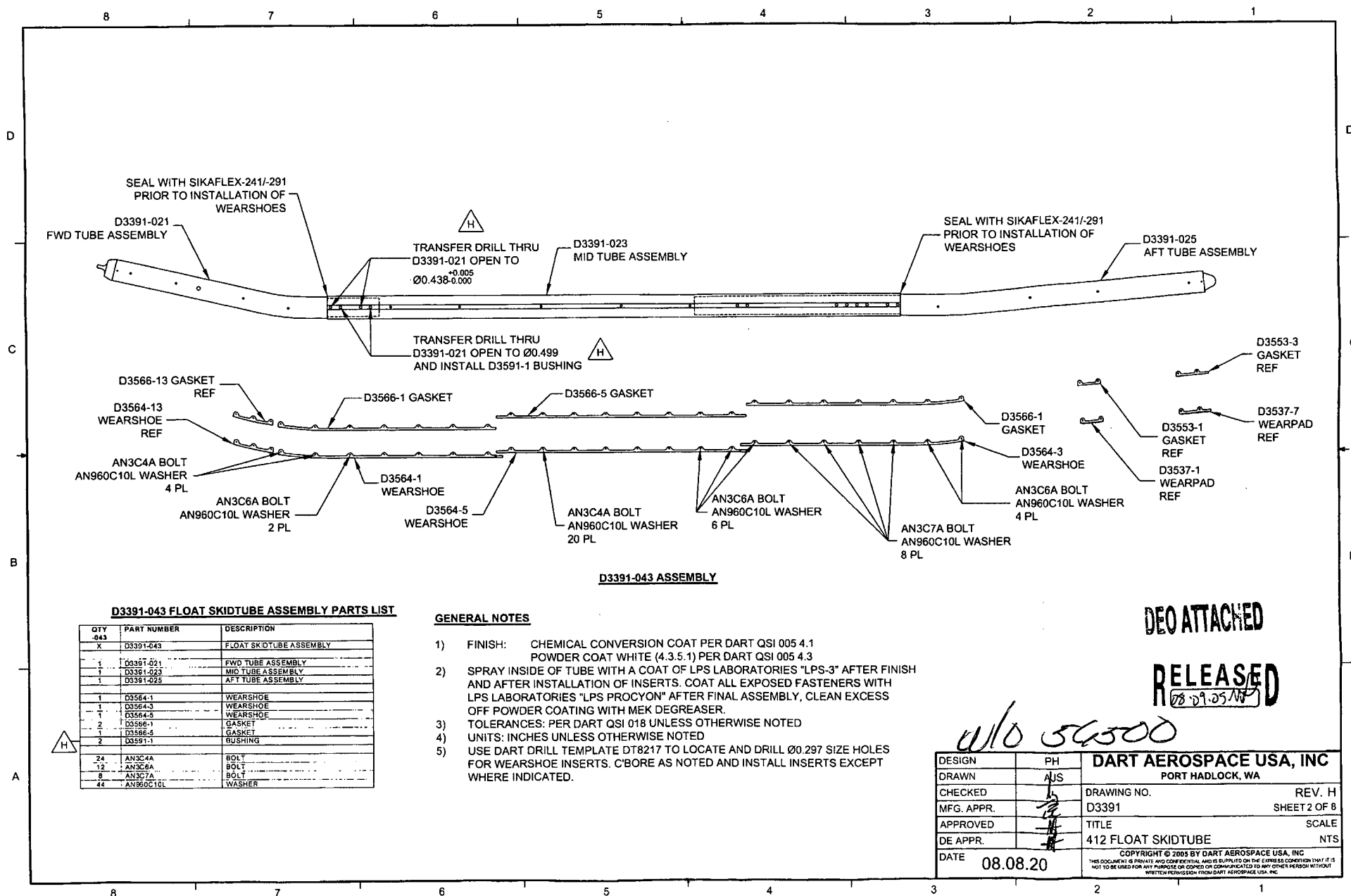
D3391-041 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

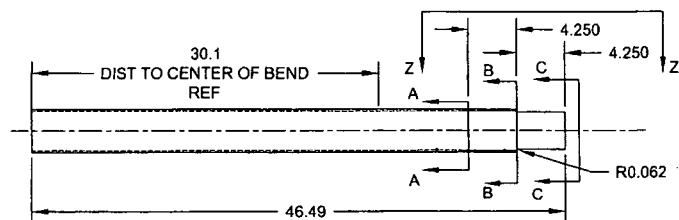
QTY	PART NUMBER	DESCRIPTION
X	D3391-041	FLOAT SKIDTUBE ASSEMBLY
1	D3391-011	FWD TUBE ASSEMBLY
1	D3391-013	MID TUBE ASSEMBLY
1	D3391-015	AFT TUBE ASSEMBLY
1	D3564-1	WEARSHOE
1	D3564-3	WEARSHOE
1	D3564-5	WEARSHOE
2	D3566-1	GASKET
1	D3566-5	GASKET
2	D3591-1	BUSHING
4	D3672-3	WASHER
24	AN3C4A	BOLT
12	AN3C6A	BOLT
8	AN3C7A	BOLT
44	AN960C10L	WASHER
4	MS27039C4-12	SCREW
4	AN960C416L	WASHER

GENERAL NOTES

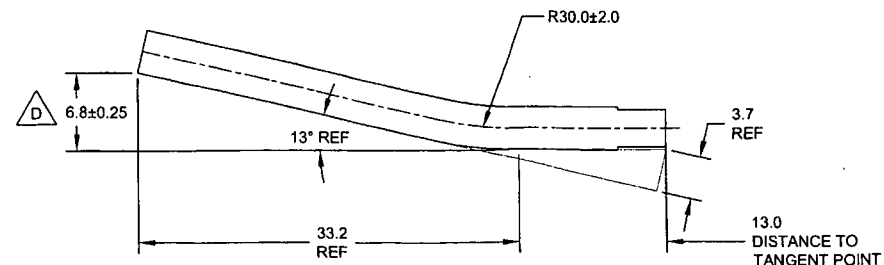
- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH
AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH
LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS
OFF POWDER COATING WITH MEK DEGREASER.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL 0.297 SIZE HOLES
FOR WEARSHOE INSERTS. CBORE AS NOTED AND INSTALL INSERTS EXCEPT
WHERE INDICATED.

H	DRAWING UPDATED TO CURRENT STANDARDS. SHT 1 PL. ADDED D3591-1 BUSHING. ZN C6 0.438 DIM WAS 4 PL. ADDED 0.499 DIM AND D3591-1 BUSHING. SHT 2 PL. ADDED D3591-1 BUSHING. ZN C6 0.438 DIM WAS 4 PL. ADDED 0.499 DIM AND D3591-1 BUSHING. (FOR FURTHER INFO SEE DSI 9364 & NCR 08-074)	AJS	08.08.20
G	REPLACE NAS INSERTS W/ AELS INSERTS SWITCH TO D3670-XXXX SPACERS FOR INSTALLING FLOAT BAGS, DWG REORGANIZED FOR CLARITY	DC	07.07.31
F	ADD SS WEARSHOE, GASKET REMOVE FWD SADDLE HOLE -011/-021	PH	07.01.18
E	CHANGE TOLERANCE, EASE MANUFACTURE	PH	06.04.25
D	UPDATE TOLERANCE, CHANGE HOLE SIZE	PH	06.01.23
C	LENGTHEN AFT EXTENSION	PH	05.09.27
B	DRAWING UPDATES	PH	05.06.10
A	NEW ISSUE	PH	05.02.07
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D3391	SHEET 1 OF 8
APPROVED		TITLE	SCALE
DE APPR.		412 FLOAT SKIDTUBE	NTS
DATE	08.08.20	COPYRIGHT © 2005 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

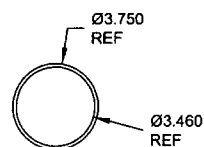




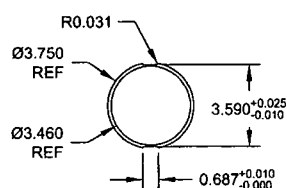
D3391-1 CUTTING DETAIL
(MAKE FROM D6013-047 SKIDTUBE MATERIAL)



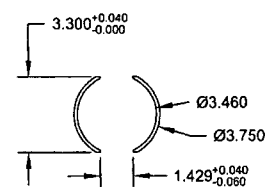
D3391-011/-021 BENDING DETAIL
(MAKE FROM D3391-1)



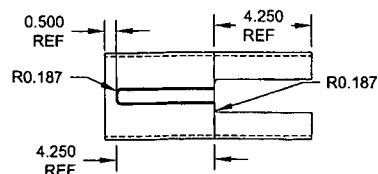
SECTION A-A
SCALE 2X



SECTION B-B
SCALE 2X



SECTION C-C
SCALE 2X

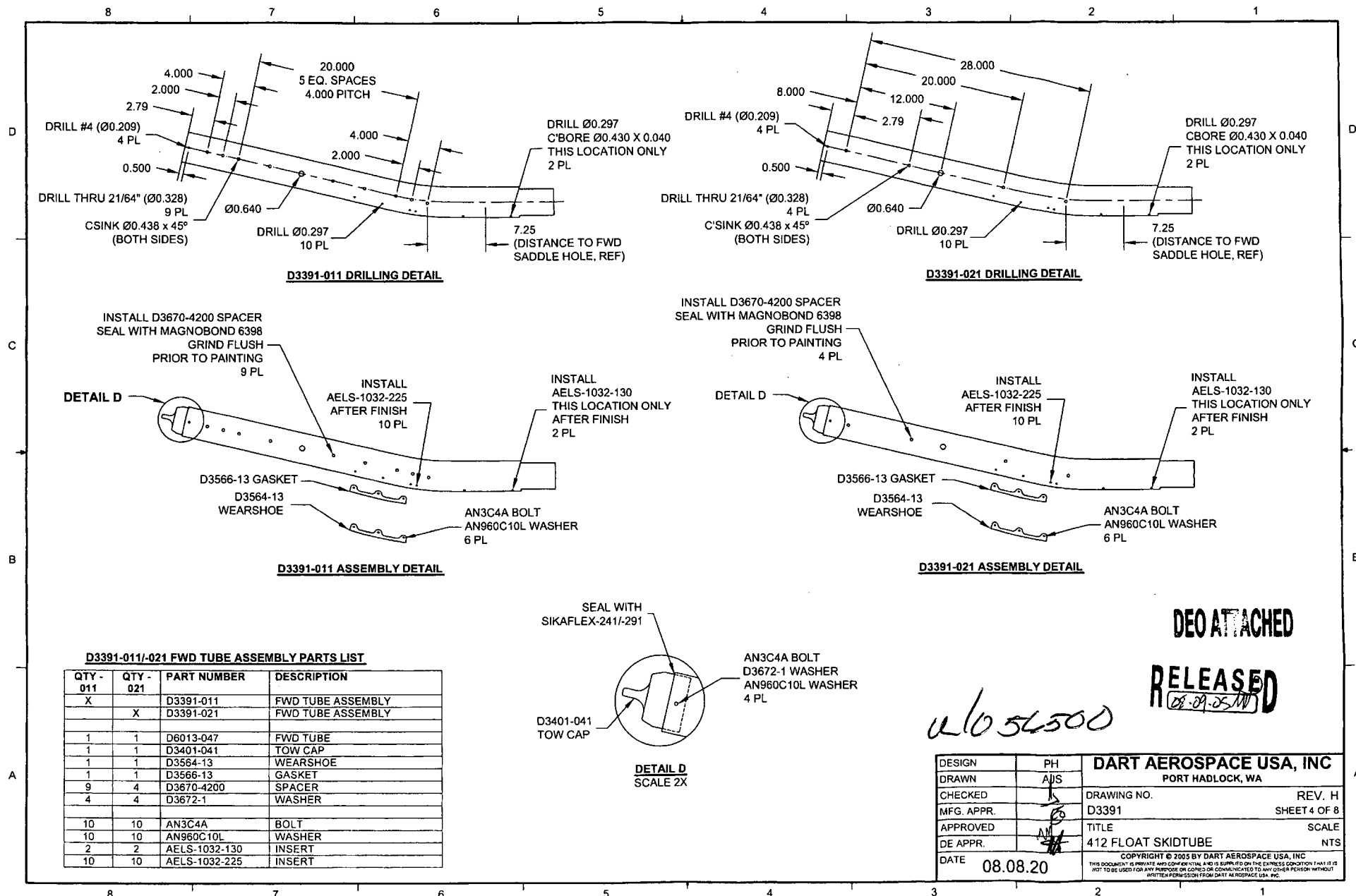


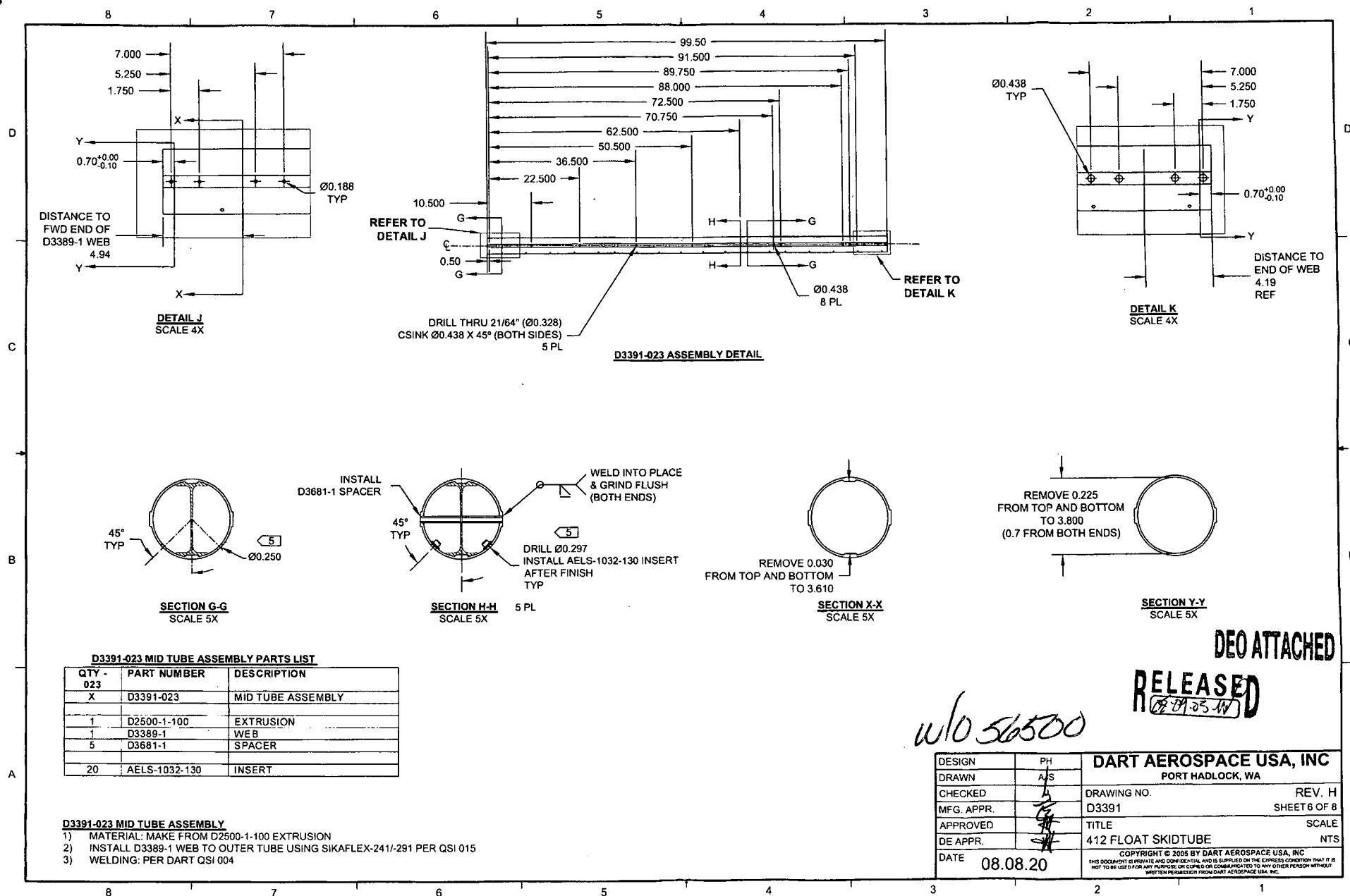
VIEW Z-Z
SCALE 2X

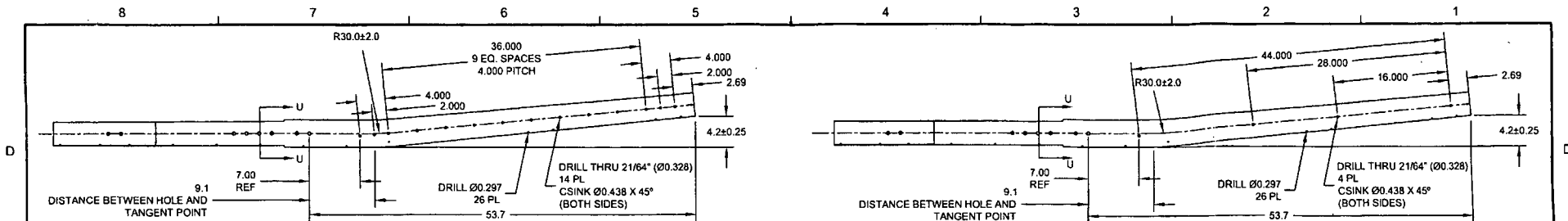
DEO ATTACHED
RELEASED
28 JAN 05

W/0 56500

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DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D3391	SHEET 3 OF 8
APPROVED		TITLE	SCALE
DE APPR.		412 FLOAT SKIDTUBE	NTS
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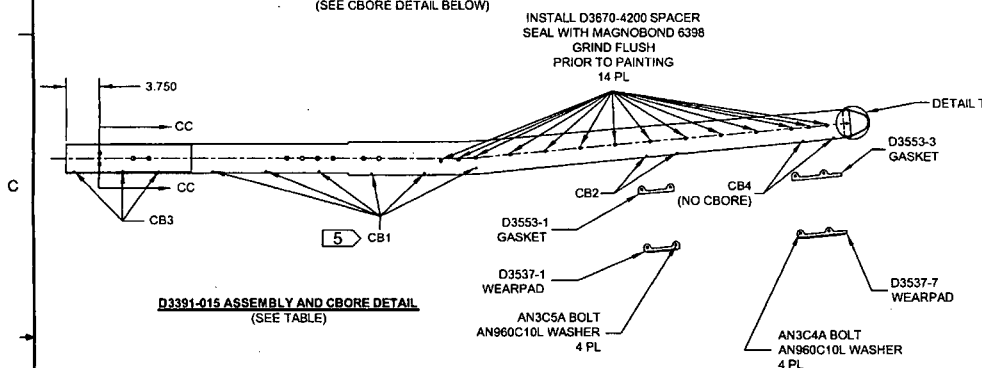




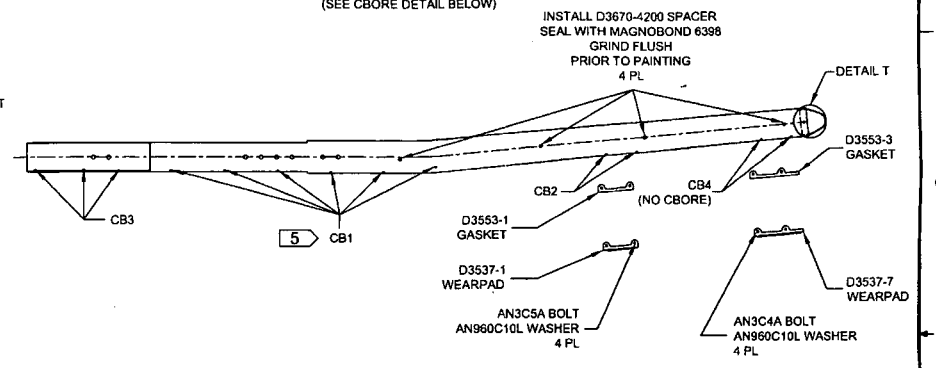


D3391-015 BENDING AND DRILLING DETAIL
(SEE CBORE DETAIL BELOW)

D3391-025 BENDING AND DRILLING DETAIL
(SEE CBORE DETAIL BELOW)



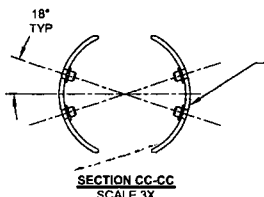
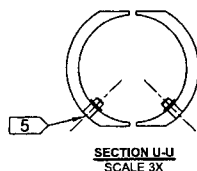
D3391-015 ASSEMBLY AND CBORE DETAIL
(SEE TABLE)



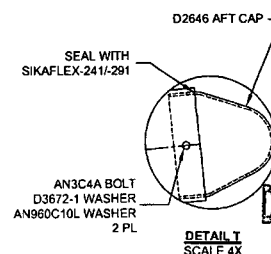
D3391-025 ASSEMBLY AND CBORE DETAIL
(SEE TABLE)

D3391-015/-025 AFT TUBE ASSEMBLY PARTS LIST

QTY - 015	QTY - 025	PART NUMBER	DESCRIPTION
X		D3391-015	AFT TUBE ASSEMBLY
	X	D3391-025	AFT TUBE ASSEMBLY
1	1	D6014-090	AFT TUBE
1	1	D2646	AFT CAP
1	1	D3537-1	WEARPAD
1	1	D3537-7	WEARPAD
1	1	D3553-1	GASKET
1	1	D3553-3	GASKET
14	4	D3670-4200	SPACER
2	2	D3672-1	WASHER
14	14	AELS-1032-130	INSERT
12	12	AELS-1032-225	INSERT
4		ALS4-428-165	INSERT
6	6	AN3C4A	BOLT
4	4	AN3C5A	BOLT
10	10	AN960C10L	WASHER



DRILL Ø0.391
CBORE Ø0.516 X 0.040 DEEP
INSTALL ALS4-428-165 INSERT
4 PL



CBORE HOLES MARKED CB1-CB4 AS FOLLOWS AND
INSTALL AELS-1032-XXX AFTER FINISH AS NOTED

HOLES MARKED	QTY D3391-015	QTY D3391-025	CBORE	P/N
CB1	12	12	Ø0.430 X 0.170	AELS-1032-225
CB2	4	4	Ø0.430 X 0.170	AELS-1032-130
CB3	6	6	Ø0.430 X 0.040	AELS-1032-130
CB4	4	4	NONE	AELS-1032-130

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	ALS	PORT HADLOCK, WA	
CHECKED	LS	DRAWING NO.	REV. H
MFG. APPR.	LS	D3391	SHEET 8 OF 8
APPROVED	LS	TITLE	SCALE
DE APPR.	LS	412 FLOAT SKIDTUBE	NTS
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DRAWING NO. D3391	TITLE 412 FLOAT SKIDTUBE	REV. H	DART AEROSPACE USA, INC ENGINEERING ORDER		D.E.O. NO. D3391-H-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>MP</i>	CHECKED <i>h</i>	MFG. APPR. <i>h</i>	APPROVED <i>MP</i>		DE APPR. <i>h</i>		
DATE 09.09.23	DATE 04.09.24	DATE 09/09/25	DATE 09/09/30		DATE 09/09/30		

PURPOSE:

LPS-3 IS NO LONGER USED DURING ASSEMBLY OF D3391-041/-043 SKIDTUBES.

CHANGE:

AMEND NOTE 2 OF D3391-041/-043 SKIDTUBE ASSEMBLIES (ZN A6-1, A6-2) AS FOLLOWS:

- 2) ~~SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH~~
~~AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH~~
 LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS
 OFF POWDER COATING WITH MEK DEGREASER.

RELEASED
 2010-02-02
MP

w/o 54500

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